

EUROPEAN PATENT OFFICE

Patent Abstracts of Japan

PUBLICATION NUMBER : 03042228
PUBLICATION DATE : 22-02-91

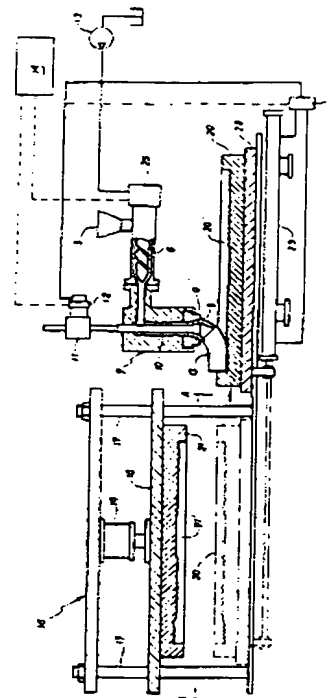
APPLICATION DATE : 10-07-89
APPLICATION NUMBER : 01177676

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INT.CL. : B29C 49/04 B29C 49/48 B29C 49/56 //
B29L 23:00

TITLE : APPARATUS FOR BLOW MOLDING OF
LONG HOLLOW ARTICLE



ABSTRACT : PURPOSE: To prepare a uniform molded product having required thickness accuracy without almost generating the positional shift due to elongation even in a long molded product by mounting the plastic parison extruded from an extruder in the molding cavity of a lower mold moving horizontally while controlling the thickness of said parison.

CONSTITUTION: A lower mold 20 is positioned directly under an extruder 7 and horizontally moved in the direction of a mold clamping mechanism 16 by the operation of a hydraulic cylinder 23 simultaneously with the extrusion of a parison 15 from the extruder 7. At this time, the extrusion speed of the parison 15 and the moving speed of the lower mold 20 are made synchronous by the order given to a hydraulic motor 25 and a servo valve 24 from a programmable controller 14 and the parison 15 is accurately mounted to the molding cavity 20' of the lower mold 20 in an accurately positioned state. The thickness of the parison 15 is controlled by the order given to a servo valve 12 from the programmable controller 14 at the same time. Compressed air is blown in the parison 15 at the same time to inflate the parison 15 and a flexible tube 4 having the outer shapes corresponding to molding cavities 20', 21' can be molded.

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